Quality Control

Work Order I June-18-14 1:55:12 I			*12	1222*						Page 1
Item ID: D345 Revision ID: Item Name: Clevi		27M	Accept	*N900	0040	100	7* s	Setup Sta	171	S1* S2*
Start Date: 6/18/	-	*10*		Cust Item				•		
Required Date: 6/18/ Reference:	/14 Req'd Qty: 10,50	⁾ *10*	•	Customer:						
Approvals: Pro	cess Plan: MUS	Date: 14-06-	SPC (Y/N):		ate:		R	tun Sta Sto	^ I/J	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									DAS 60
D3453	Rev B									40 EZ
100			0.00			-			<u> </u>	
100 Doosan	Мето		0.00	ea.			19	\mathcal{D}	_	14-7-7
Doosan Lathe	1-Turn as Rev: <u>0</u> 11 Dwg D34	eper Folio FA578 & <u>Rev:</u> as per dwg D3453								
· 150	QC2- Inspect parts off	machine FAI/FAIB	0.00							SVQ
150 oc	Мето		0.00	٠.			19	Ø		14-7-7
Quality Control										
1								•		
160	QC8- Inspect parts - se	econd check	0.00							DAS
160	Memo		0.00				19	Ø	<u> </u>	44 14 (0구/ 9-89

DQA:			Date:						DA 4 4 4 6				*DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFO	RMANCE / UPDATE	Wo	ork Order up	odate only	AEROSPACE
			·			DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	-					Rework			Skid-tube Crosstube	-	Dura	Water Jet	Engineering
Part N NCR N	-			· · · · · · · · · · · · · · · · · · ·		Scrap Use-as-is Suspected Unapproved			Machining Small Fab noforming Finishing Large Fab Composite		1	d. Eng. Coor. re/Packaging Supplier	Quality Other
NCK I	٠٠٠.					Suspected Onapproved			composite		<u> </u>	Supplier[_	<u> </u>
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance		nitial iief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design								<u>v</u>					
Doc/Data Equip/Tooling	Н												
Handling/Pre	世角	3											
Material	~ .												
Operator									,				
Offset/Setup												٠.	
Process						<i>:</i>							
Supplier													
Training													•
Transport Unapproved							:						
, ⁵							FA	ULT CA	TEGORY				
Landi	ng C	Gear				General		•		_	-	_	7
		Bending				Bend		Folio/F	Program	_	Outside Dim		Pressure/Forced
	Ш	Centre N	ot Concer	ntric		BOM/Route	_	Grain		┕	Over/Under		Set-up
		Cracks				Broken/Damage/Defect		Hardwa		<u>_</u>	Part Incorre	<u> </u>	Temperature/Cure
	\vdash	Crimp/Kii	nk/Ripple	/Wave		Burrs	<u> </u>	- 1 '	ion Incomplete/Unqualified	\vdash	Part Lost/M	issing	Weld
	-	Cuffs				Contamination	L	4	tions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
		Crushing			_	Countersink			gned/off center		Positioned V		¬₋.
,	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislab			Power Loss/	Surge	Other
	Щ	Inspectio		Tube	<u> </u>	Drawing	<u> </u>	Misrea					
		Marks/Cl			<u> </u>	Drill Holes	-	Off-set					
		Turning S			\vdash	Finish	_	-4	Calibration				
1	1	Wave/Tw	vist in Tub	e		Fit/Function	1_	Out of	Sequence				

Work Ord <i>June</i> ; 18-14 1:		21222		*121	1222*							Page	: 2
Item ID: Revision ID: Item Name:	D3453-3 Clevis			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop		S1*	
Start Date: Required Date Reference:	6/18/14 e: 6/18/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:		,					
Approvals:	Process P	Plan:	Date:	Tooling:	Da Da	ate:	_		Run	Start	*N	R1 *	
; 1			Date:	SPC (Y/N):	Da	ate:				Stop	*NI	R2*	
Sequence ID/ Work Center 170 *170* Packaging	ID	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	7 I	Reject Number	Insp. Stamp	
Packaging		*****STOCI QC21- Final Inspection -	X IN LARGE FAB***** Work Order Release	0.00								(

0.00

Memo

1 RN

Quality Control

MLJ 14-07-08 MK 4-8

DQA:			Date:										TAART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:							V	Vork Order up	odate only	
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIK OIGE	-					Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing	-	re/Packaging	Other
NCR N	۱٥			·		Suspected Unapproved			Large Fab	Composite		Supplier	
Root	7	Des		Desci	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	l	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design			,							<u> </u>			
Doc/Data												•	
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process	Ш					l i				-			
Supplier							ĺ						
Training										•			
Transport					,						İ		
Unapproved				<u> </u>			<u> </u>						<u></u>
		<u> </u>					FAL	ULT CA	TEGORY		in the second		
Landi	$\overline{}$				_	General	r] <i> </i>		Г	Outside Dim	: Г	Pressure/Forced
		Bending				Bend	-	1	Program	-	Over/Under	—	Set-up
	\vdash	Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		-	Part Incorre	-	Temperature/Cure
	$\overline{}$	Cracks	d./Dimmlo	/\4/=	-	Broken/Damage/Defect	\vdash	Hardwa	ire ion Incomplete/Un	auglified	Part Lost/M	· · ·	Weld
	\vdash	Crimp/Kin Cuffs	ік/кірріе,	/ wave	\vdash	Burrs Contamination		1	tions Incomplete/U	· –	Part Moved	- ISSII IS	Wrong Stock Pulled
	├──┤				\vdash	Countersink		4	gned/off center	, inclear	Positioned \	L. Mrong	
	$\boldsymbol{\vdash}$	Crushing Heat Trea	.+		-	Cut Too Short	_	Mislabe		 	Power Loss/	_	Other
	${m -}$	Inspection		Tuhe		Drawing	-	Misrea		. L	الــــا، ٥٠٠٠ ا		1-3-3-
		Marks/Ch	-	, ube		Drill Holes	_	Off-set					
i ,	H	Turning S			<u> </u>	Finish	—	•	Calibration				
l	L					Fit/Function	\vdash	4	**				

June-18-14 1:55:15 PM

Work Order ID: 121222

121222

Parent Item: Parent Item Name: Clevis

D3453-3

D3453-3

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No		100	f	22.5133	0.2452	3		/3 /3	\$
N/20/121	250		•					**	įŪ	-11	100	

304 round bar 1.250

Location	Loc Qty	Loc Code	
MAT029	22.5133		
m126151	1.8		
m126647	12		
m128496	8.7133		7,05

DQA: Date:					_								TAART
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		Date:							W	ork Order up	date only		
					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS		
Work Order:	:					1		Child Andread Connections		7	Water Jet		Engineering
Dart No					Rework Scrap	1		Skid-tube Crosstube Machining Small Fak		Dro	d. Eng. Coor.	Н	Quality
Part No	'•	-		—	Use-as-is	1		noforming Finishing	_	4	re/Packaging	Н	Other
NCR No).				Suspected Unapproved	1	111011	Large Fab Composite	\vdash	1.00,010	Supplier	$\boldsymbol{\vdash}$	
1	· · · · · · · · · · · · · · · · · · ·							·					
Root	3			Desc	ription of work order update	П	Initial	Action	,	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design													
Doc/Data	_											l	
Equip/Tooling	_												
Handling/Pre	_							i		}			
Material	_												
Operator													
Offset/Setup													
Process													•
Supplier												Î	
Training	_					İ							
Transport	_],						, ,			
Unapproved	<u></u>		<u> </u>					<u> </u>		<u> </u>			<u> </u>
						FA	ULT CA	TEGORY		- 			
Landing	Gear				General	_	· · · · · ·		_	7			<u>.</u> .
	Bending			<u> </u>	Bend	_	4	Program	<u> </u>	Outside Dim		-	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain	· · · ·	\vdash	Over/Under		_	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	· **	_	Part Incorre		Н	Temperature/Cure
j .L	Crimp/Ki	nk/Ripple	e/Wave	_	Burrs		-1	tion Incomplete/Unqualified	\perp	Part Lost/M	issing	-	Weld
	Cuffs				Contamination	\perp	4 .	tions incomplete/Unclear	_	Part Moved			Wrong Stock Pulled
	Crushing			L	Countersink	L	- · · · · ·	ḡned/off center		Positioned \			i
	Heat Tre	at		L	Cut Too Short	L	Mislab			Power Loss/	'Surge		Other
	Inspection	n Strip in	Tube		Drawing	\perp	Misrea	d . **.					
	Marks/C	hatter			Drill Holes		Off-set	:					
	Turning :	Sequence	!		Finish	L	Out of	Calibration					
	Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	16126
DAKT AEROSI AGE ETO	Part Number:	D3453-3
Description: Clevis	T divitation.	
Inspection Dwg: D3453 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+/-0.030	1.125				
Ø0.755	+0.002/-0.005	.751				
2.74	+/-0.030	2737				
1.220	+/-0.010					
1.00	+/-0.030	1.00		-	·	
0.500	+0.010/-0.000	378				
Ø0.375	+0.006/-0.001	378				
Ø0.129	+0.005/-0.001	.1285			,	
0.625	+/-0.010	-625				
0.450	+/-0.010	.454				
				 		
112x45	7.00/7.50	110 x 450				
5 %		·		*		
<u> </u>						
	-					
	,					

		60		UAS		
ı		8 2 8	Audited by:		Preliminary Approval:	
	Measured by:	- W	ridditod 2).	9-89	D-4	
	Date:	14-7-7	Date:	14/07/08	, Date:	

			Revised by Approved
Rev	Date	Change	KJ/JLM
Α	06.09.01	New Issue	KJ 10
В	09.11.04	Dimensions updated per Dwg Rev B	KJ 📲 M
C	13.04.12	Tolerance updated for dimension Ø1.13	1 / / / / / / / / / / / / / / / / / / /
			1/



SHOP COPY **RETURN TO**

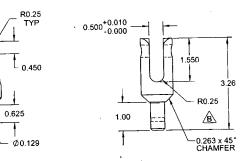
ENGINEERING

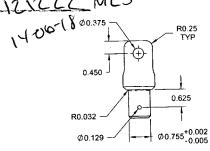
UNCONTROLLED COPY

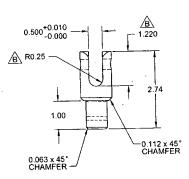
SUBJECT TO AMENDMENT

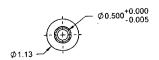
WITHOUT NOTICE

WORK ORDER MLJ











D3453-1 CLEVIS

D3453-3 CLEVIS /

В	DRAWIN WAS 0.0 REF PA	NG UPDATED T 050 (ZN C5-1, C R 09-018	RF	09.05.21		
A	NEW IS			RF	05.09.02	
REV.	T		DESCRIPTION	BY	DATE	
DESIG	N	RF	DART AEROSP			
DRAW	N	RF	HAWKESBURY, ONTAI	RIO, CANA	DA	
CHEC	(FD	(18)	DRAWING NO.		REV. B	
MFG.		1	D3453		SHEET 1 OF 2	
APPRO		K.	TITLE		SCALE	
DE APPR.			CLEVIS NTS			
DATE	09.0	05.21	COPYRIGHT © 2005 BY DAR THIS DOCUMENT IS PREVATE AND CONFIDENTIAL AND IS SUPP HOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMU	MED ON THE FRAME MEATED TO ANY OT	IS CONDITION THAT IT IS	

D3453-1/-3 NOTES:

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

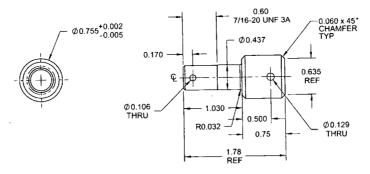
7) WEIGHT: D3453-1 = 0.41 lbs

D3453-3 = 0.41 lbs

Ø0.438

R0.032

0.063 x 45° CHAMFER



D3453-5 PLUG

D3453-5 NOTES:

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.13 lbs

DESIGN RF DRAWN RF DRAWING NO. CHECKED D3453 MFG. APPR APPROVED TITLE DE APPR. **CLEVIS** DATE 09.05.21

REV. B SHEET 2 OF 2 SCALE NTS

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DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA